

Date: Tuesday, 11/6/2007 3:41:56 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SUPPORT GUSSET (350) BASKET	
Job Number	35584				
Estimate Number	10496				
P.O. Number	N/A		Part Number	D2325	
This Issue	11/6/2007	S.O. No.	Drawing Number	D2325 REV B	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	B	
Previous Run	33279		Material	N/A	
Written By			Due Date	11/26/2007	
Checked & Approved By			Qty:	60	Um: Each
Comment	Est. D 02.12.06 Reformat; Rev B KJ/RF				
	Est. E 06.05.03 Water jet EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.4883 sf(s)/Unit Total : 29.2950 sf(s) 304/316 SS .063 Sheet Batch: 105997 LB 07-11-12		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2325 Dwg Rev: B LB 07-11-12 Prog Rev: B		
2-Deburr if necessary LB 07-11-12		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE LB 07-11-12		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>Jan-11-14</i> (60) counted.		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 01/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 3:41:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 35584

Part Number: D2325

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



N/A



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



welding part D.



Comment: PACKAGIN

Identify and Stock

Location: WS

D 01-11-16

(60)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

H 01/11/19

Job Completion



N 01-11-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35584
Description: Support Gusset	Part Number:	D2325
Inspection Dwg: D2325 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>AB</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	07-11-15	Date:	<u>07-11-14</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.08	New Issue	KJ/JLM	SJT

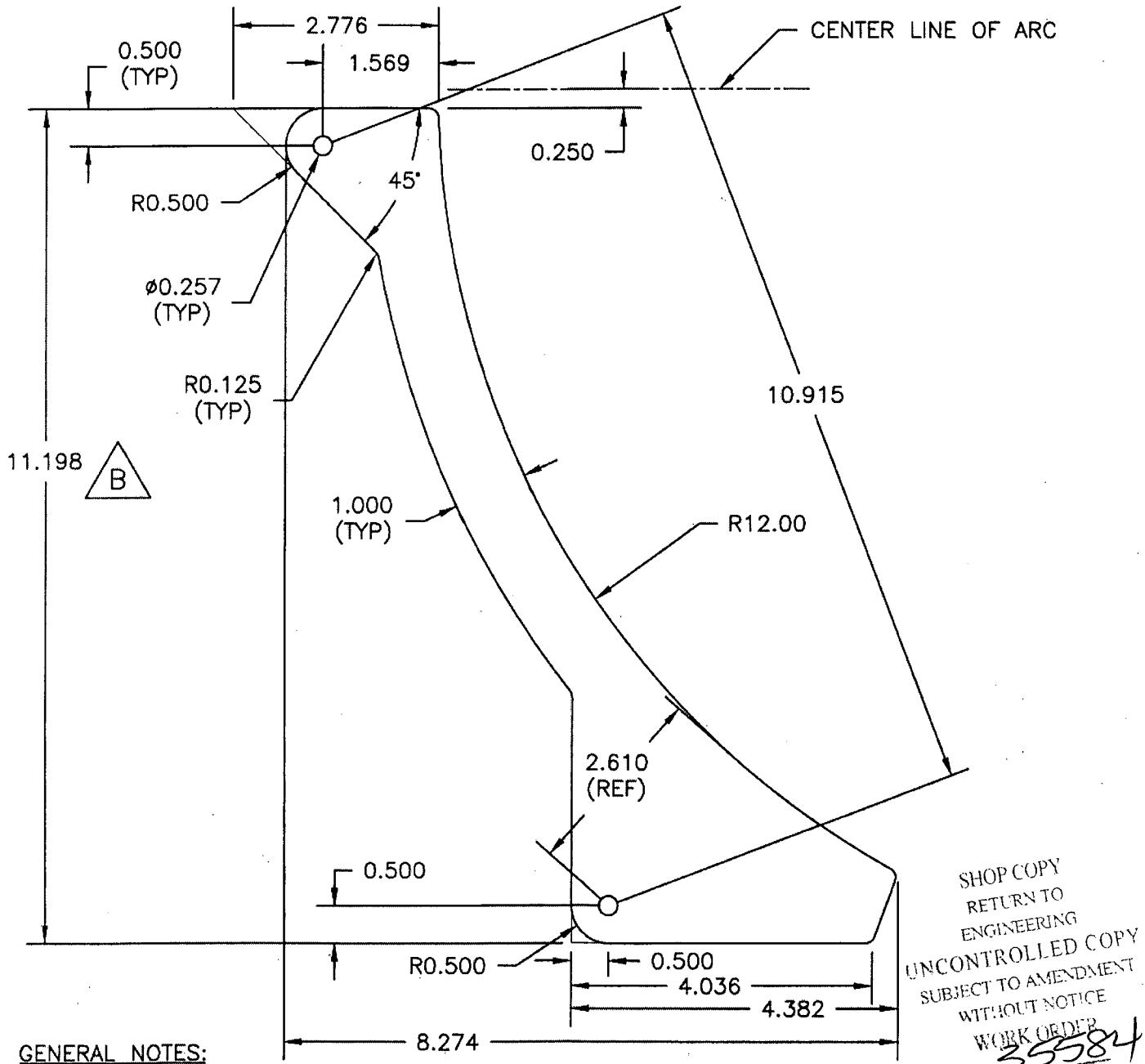


02/08/28
02/08/28

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2325 REV. B SHEET 1 OF 1
DATE		TITLE SUPPORT GUSSET SCALE 1:2
02.08.28		

RELEASED
02.08.29

A	94.12.13	NEW ISSUE
B	02.08.28	REFORMAT; 11.198 WAS 11.948



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35584

GENERAL NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.